

ASAP

Dart Aerospace Ltd.

Date: Thursday, 31/01/2008 8:18:37 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WASHER
Job Number : 37123	
Estimate Number : 11314	
P.O. Number :	Part Number : D34571
This Issue : 31/01/2008 S.O. No. :	Drawing Number : D3457 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 34640	Material :
Written By :	Due Date : 01/02/2008 Qty: 40 Um: Each
Checked & Approved By :	
Comment : Est. A05.10.03 New issue KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MDELINR1000	Delrin Round Bar 1"
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Comment: Qty.: 0.0218 f(s)/Unit Total: 0.8736 f(s)
Delrin Round Bar 1"
Material: Delrin Round Bar Ø1.000
(M-DELRIN-R1.000)
Batch: M103109
Identify for D3457-1

J.F. 08/02/01 (47)

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL
Turn as per Folio FA589 Rev: AA & Dwg D3457 Rev: A

J.F. 08/02/01 (47)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment:
Machine as per Folio FA589 Rev: AA & Dwg D3457 Rev: A

J.L. 08/02/06 (46)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L. 08/02/06 (46)

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J.F. 08/02/06 (46)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: P Date: 08/02/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/02/06	3	- 1 part flew off of tape - can't put back	<u>08/02/06</u>	- scrap no replace Qty (4)	J.L. 08/02/06	<u>08/02/06</u>	<u>08/02/06</u>	<u>08/02/06</u>

NOTE: Date & initial all entries

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Drawing Name: WASHER

Job Number: 37123

Part Number: D34571

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr

J.L 08/02/06

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: 5790

P.C. 8/2/06 46

8.0

QC21

FINAL INSPECTION/W/O RELEASE



(46)

Comment: FINAL INSPECTION/W/O RELEASE

2008/02/08

Job Completion



2008/2/07 (46)

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

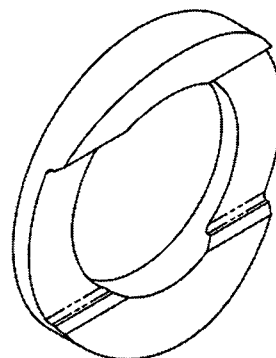
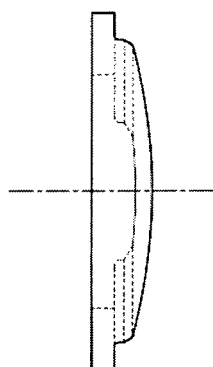
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

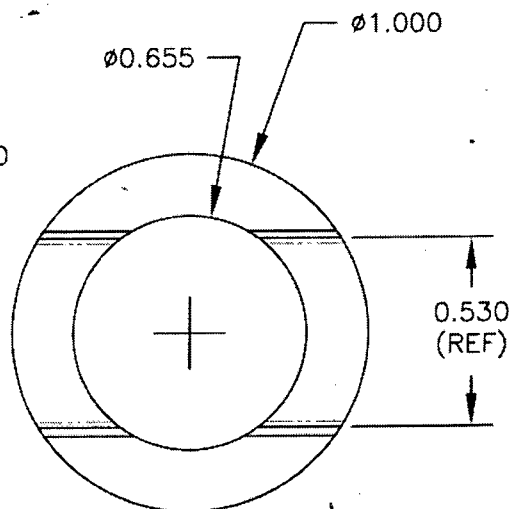
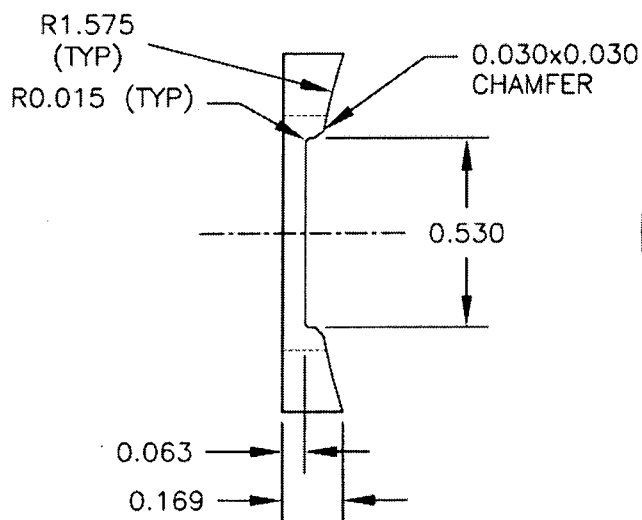


DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3457	REV. A SHEET 1 OF 1
DATE 05.09.06		TITLE WASHER	SCALE 2:1
A	05.09.06	NEW ISSUE	

05.09.06 [Signature]



ISOMETRIC DETAIL



WLO 3/12/03

D3457-1 WASHER

- 1) MATERIAL: DELRIN (DART SPEC. M-DELRIN-R)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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